

Work Order ID 81956

81956

March-21-12 1:42:09 PM

Item ID: D2570 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bushing
Start Date: 21/03/2012 Start Qty: 400.00 *400* Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 400.00 *400* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2570	Rev B

100	Hardinge CNC LATHE SMALL	0.00	<u>36</u> / <u>RQ</u> 12.4.9 400 0 <u>36</u>						
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per folio FA258Deburr								

110	QC2- Inspect parts off machine FAI/FAIB	0.00	<u>36</u> / <u>RQ</u> 12.4.9 400 0						
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00	<u>ML</u> 12/04/11 400 0						
120									
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST 011</u>	0.00							
130									
Packaging	Memo	0.00				(400)			12/04/11 JB
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12/4/12 JB
Quality Control									

12-04-12

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Picklist Print

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Parent Item: D2570

D2570

Parent Item Name: Bushing

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP E02.08.29Re-format; Removed finishing; Material changeKJ
IPP F 07.07.06 rev B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	68.8700	0.0771	32.46316			

M303R0 750

303 Round Bar 0.750

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	68.87	
117328	13.242	
117798	4.004	
118509	4.08	
119346	0.645	
120145	10.566	
120603	12.333	
121070	24	

121282

32.4

36 rebar in

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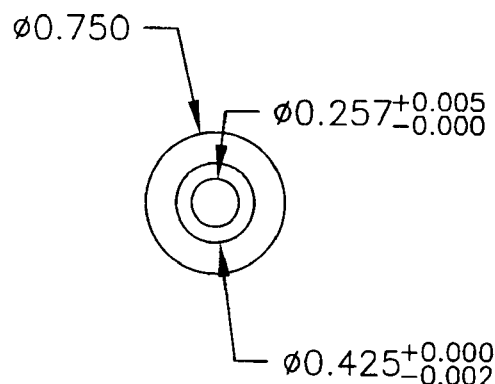
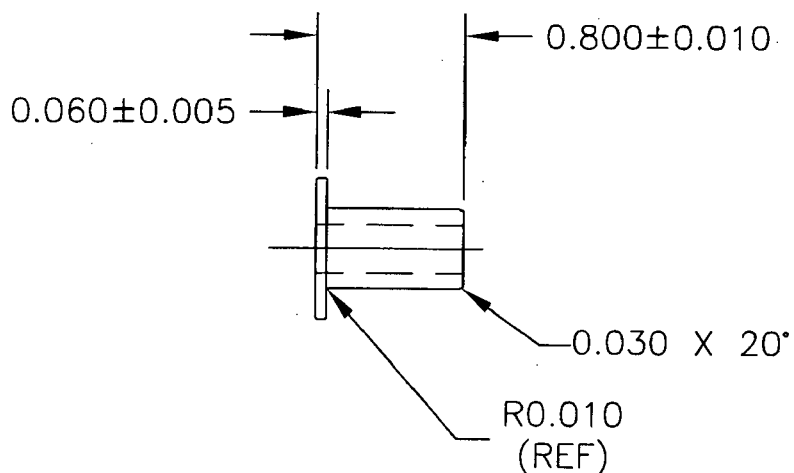
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 *PH***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21956 MCS
12/03/21

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